

Work Order ID 84698

May-22-12 1:02:57 PM

84698

Page 1

Item ID: D4464-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Tank Assembly
 Start Date: 22/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4464	D								

100 Weld per dwg A/R Aluminum rod Batch: 120854 0.00

100

Large Fab

Large Fab

Memo

0.00

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4463-11 as per dwg D4464

2- Weld D4001-1 and D4000-5 onto D4463-1 Top

2- Weld D4463-9 and D4463-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4463-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4463-7 fwd end

PURGE INSIDE OF TANK

1 0 ll
12-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84698

84698

Page 2

May-22-12 1:02:57 PM

Item ID: D4464-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Tank Assembly
 Start Date: 22/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				1	0	02/06/11	
120 *120* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>120834</u> Memo 1-Weld top D4463-1 ***PURGE INSIDE OF TANK***	0.00 0.00				1	0		12-06-12
123 *123* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***Pressure Test as per dwg D4464***	0.00 0.00							5/7/06/13 no leaks (with + vacuum pump)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84698

May-22-12 1:02:57 PM

84698

Page 3

Item ID: D4464-041
 Revision ID:
 Item Name: Fuel Tank Assembly
 Start Date: 22/05/2012 Start Qty: 1.00
 Required Date: 05/06/2012 Req'd Qty: 1.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				1	0	2512/06/13	
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo 1- brush alodine on tank. No alodine inside	0.00 0.00				IX	0	12/06/13	M-L
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				1-X	0	12/06/14	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84698

84698

Page 4

May-22-12 1:02:57 PM

Item ID: D4464-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Tank Assembly
 Start Date: 22/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170									
Powdercoat	Memo	0.00							
Powder Coating	***Mask prior to powdercoat***								
	POWDER COAT ANSL61 GREY AS PER DWG AND QSI 005 4.3								
	Start Time: 2:45								
	Oven Temperature: 320 F								
	Finish Time: 3:15								
180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									

M 118533

IX ~~✓~~ m.f. 2/06/13

1 ~~✓~~ BR 12613

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84698

May-22-12 1:02:57 PM

84698

Page 5

Item ID: D4464-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Tank Assembly
 Start Date: 22/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Small Fab	Memo	0.00							
Small Fab	1- Mask off area, where access cover is applied								
	2- Abrade surface with red scotch brite								
	3- Wipe with clean cloth and wash and wipe								
	4- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890								
	A/R proseal 890 Batch: M2/2/284								
200 *200* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
	Tested with water and air pressure to 45psi								

12-06-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

May-22-12 1:02:57 PM

Item ID: D4464-041
Revision ID:
Item Name: Fuel Tank Assembly

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 22/05/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 05/06/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210	Identify as per dwg & Stock Location:_____	0.00
-----	--	------

210

Packaging

Packaging

Memo

0.00

220

QC21- Final Inspection - Work Order Release	0.00
---	------

220

QC

Quality Control

Memo

0.00

12/6/18 ~~JD~~
mf
12-06-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 1:03:00 PM

Page 1

Work Order ID: 84698

84698

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B
12.03.08 AS PER DWG REV.B DD VERF:EC IPP REV:C 12.04.24
ECN 12-571 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-5 *D3997-5* Placard		Manufactured	No			190	Each	12.0000	2	2			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST141				102					
				72611				82					
				81028				8					
				83650				12					
D3997-11 *D3997-11* Placard		Manufactured	No			190	Each	13.0000	1	1			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST141				13					
				80308				1					
				82957				12					
D3997-17 *D3997-17* Placard		Manufactured	No			190	Each	15.0000	1	1			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST141				15					
				80309				4					
				82958				11					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 1:03:00 PM

Page 2

Work Order ID: 84698

84698

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3997-29

Manufactured No

190

Each

16.0000

1

1

D3997-29

Placard

**

12/06/15

Location

Loc Qty

Loc Code

ST141

16

80845

16

D3997-43

Manufactured No

190

Each

13.0000

1

1

D3997-43

Placard

**

12/06/15

Location

Loc Qty

Loc Code

ST141

13

80310

1

82960

12

D3999-7

Manufactured No

100

Each

7.0000

1

1

D3999-7

Corner

**

12.06.12

Location

Loc Qty

Loc Code

WA014

7

71695

1

75156

6

D3999-9

Manufactured No

100

Each

6.0000

1

1

D3999-9

Angle

**

12.06.06

Location

Loc Qty

Loc Code

WA014

6

71696

1

82545

5

May-22-12 1:03:00 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 1:03:00 PM

Page 3

Work Order ID: 84698

84698

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3999-11

Manufactured No

100

Each

20.0000

1

1

✓ ***D3999-11***

Earth Tab

**

12.06.06

Location

Loc Qty

Loc Code

WA

27

84161

19

WA013

-8

WA014

1

75180

1

D4000-1

Manufactured No

100

Each

11.0000

1

1

✓ ***D4000-1***

Fuel Supply Fitting

**

12.06.08

Location

Loc Qty

Loc Code

WA

11

80029

1

83811

10

D4000-5

Manufactured No

100

Each

9.0000

1

1

✓ ***D4000-5***

Fuel Tank Vent Fitting

**

12.06.07

Location

Loc Qty

Loc Code

WA013

9

80030

1

83813

8

D4000-9

Manufactured No

100

Each

8.0000

3

3

✓ ***D4000-9***

Grommet

**

12.06.07

Location

Loc Qty

Loc Code

WA014

8

83814

8

May-22-12 1:03:00 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 1:03:00 PM

Page 4

Work Order ID: 84698

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

84698

D4464-041

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4000-045

Manufactured No

100

Each

5.0000

1

1

**

12.06.11

D4000-045

Fuel Pickup Fitting Assembly

Location

Loc Qty

Loc Code

WA

1

81071

1

WA013

3

72078

1

82696

2

WA014

1

71669

1

D4008-11

Manufactured No

100

Each

10.0000

1

1

**

12.06.06

D4008-11

Hinge Half

Location

Loc Qty

Loc Code

WA

10

80037

2

80838

8

D4008-041

Manufactured No

190

Each

1.0000

1

1

**

12/06/15
B84013
(12)

D4008-041

Fuel Filler Splash Guard Assembly

Location

Loc Qty

Loc Code

ST142

1

78910

1

May-22-12 1:03:00 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 1:03:01 PM

Page 5

Work Order ID: 84698

84698

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4023-3

Manufactured No

190

Each

8.0000

1

1

D4023-3

Cap and Flange

**

12.06.06

Location

Loc Qty

Loc Code

ST084

6

81898

6

ST110

1

73514

1

WA

1

80032

1

D4025-5

Manufactured No

190

Each

6.0000

1

1

D4025-5

Fuel Quantity Sender

**

12.06.10

Location

Loc Qty

Loc Code

ST141a

6

76894

2

81899

4

D4057-1

Manufactured No

100

Each

30.0000

3

3

D4057-1

Retaining Ring

**

12.06.07

Location

Loc Qty

Loc Code

WA013

30

71166

3

81889

3

83656

24

D4062-041

Manufactured No

190

Each

0.0000

1

1

D4062-041

Tank Support Assembly

**

12.06.12

385235 = 1

May-22-12 1:03:01 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 1:03:01 PM

Page 6

Work Order ID: 84698

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

84698

D4464-041

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D4124-1
D4124-1
Tab

Manufactured No

100

Each

29.0000

4

4

**

12.06.12

Location

Loc Qty

Loc Code

WA

29

76895
83824

7

22

4

D4125-1

Manufactured No

100

Each

5.0000

1

1

**

12.06.06

Location

Loc Qty

Loc Code

WA

5

81151
83825

1

4

1

D4125-3

Manufactured No

100

Each

5.0000

1

1

**

12.06.06

D4125-3
End

Location

Loc Qty

Loc Code

WA

5

81152
83826

1

4

1

D4404-3

Manufactured No

100

Each

3.0000

1

1

**

12/06/15

D4404-3
Cushion, Side

Location

Loc Qty

Loc Code

ST242A

3

76898

3

1

May-22-12 1:03:01 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 1:03:01 PM

Page 7

Work Order ID: 84698

84698

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4404-5 Manufactured No

100 Each 1.0000 4 4

D4404-5

Cushion, Fwd

**

Location

Loc Qty

Loc Code

ST242A

1

76899

1

Manufactured No

100 Each 4.0000 1 1

D4462-1

D4462-1

Baffle

**

Location

Loc Qty

Loc Code

WA

4

83827

4

Manufactured No

100 Each 2.0000 1 1

D4462-3

D4462-3

Baffle

**

Location

Loc Qty

Loc Code

WA

2

83828

2

Manufactured No

120 Each 0.0000 1 1

D4463-041

D4463-041

Tank Top Assembly

D4463-3

Manufactured No

Each 2.0000 1 1

D4463-3

Tank Aft End

**

Location

Loc Qty

Loc Code

WA

2

83833

2

B 84826 = (1) 100

May-22-12 1:03:01 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 1:03:01 PM

Page 8

Work Order ID: 84698

84698

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4463-5

Manufactured No

100

Each

10.0000

1

1

D4463-5

Tank Upper Cut Out

**

12.06.07

Location

Loc Qty

Loc Code

WA

10

83834

10

D4463-7

Manufactured No

100

Each

2.0000

1

1

D4463-7

Tank Fwd End

**

12.06.12

Location

Loc Qty

Loc Code

WA001

2

83836

2

D4463-9

Manufactured No

100

Each

2.0000

1

1

D4463-9

Tank Back

**

12.06.07

Location

Loc Qty

Loc Code

WA001

2

83837

2

D4463-11

Manufactured No

100

Each

0.0000

1

1

D4463-11

Tank Front

**

12.06.06

D4463-13

Manufactured No

190

Each

5.0000

1

1

D4463-13

Tank Bottom

**

12.06.06

Location

Loc Qty

Loc Code

WA

5

82237

2

83831

3

May-22-12 1:03:01 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 1:03:01 PM

Page 9

Work Order ID: 84698

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

84698

D4464-041

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3H5A

Purchased

No

190

Each

37.0000

5

5

AN3H5A

Bolt

**

Location

Loc Qty

Loc Code

ST351

37

118112

1

120693

36

MS21042L3

Purchased

No

190

Each

2,496.000

4

4

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

2496

117885

32

119017

1076

119075

138

121349

345

121444

905

MS35206-266

Purchased

No

190

Each

96.0000

4

4

MS35206-266

Screw

**

Location

Loc Qty

Loc Code

ST294

96

119850

96

AN3-GA

M120644 (4x)

NAS 1149 DO 332 J

(5x)

M119717

May-22-12 1:03:01 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 1:03:01 PM

Page 10

Work Order ID: 84698

84698

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

190

Each

2,553.000

37

37

NAS1149D0363.J

Washer

**

EP 12/06/15

Location

Loc Qty

Loc Code

ST298

2553

117601

61

118077

1

118612

18

119537

33

120142

41

120308

17

120644

122

121243

760

121524

1500

32

AN3-4A

Purchased

No

190

Each

654.0000

24

24

AN3-4A

Bolt

**

EP 12/06/15

Location

Loc Qty

Loc Code

ST350

654

102832

88

104291

4

104625

184

117317

98

120308

80

120770

200

24

D4577-1

Manufactured

No

190

Each

1.0000

1

1

D4577-1

Rear Access Panel

**

EP 12/06/15

Location

Loc Qty

Loc Code

ST237A

1

83839

1

B84365

(IX)

May-22-12 1:03:01 PM

Shop Packet Print

Page 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 1:03:01 PM

Page 11

Work Order ID: 84698

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

84698

D4464-041

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4577-3

Manufactured No

190

Each

1.0000

1

1

**

D4577-3

Middle Access Panel

Location

Loc Qty

Loc Code

ST237A

1

83840

1

D4577-041

Manufactured No

190

Each

1.0000

1

1

**

D4577-041

Fwd Access Panel Assembly

Location

Loc Qty

Loc Code

ST237A

1

83838

1

B 85719

B 12/06/15

B 84368
102

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4464-041	FUEL TANK ASSEMBLY
2	2	D3997-5	PLACARD "AUX FUEL DRAIN"
3	1	D3997-11	PLACARD "LOADING"
4	1	D3997-17	PLACARD "STOWAGE"
5	1	D3997-29	PLACARD "WARNING"
6	1	D3997-43	PLACARD "EARTH"
7	1	D3999-7	CORNER
8	1	D3999-9	ANGLE
9	1	D3999-11	EARTH TAB
10	1	D4000-1	FUEL SUPPLY FITTING
11	1	D4000-5	FUEL TANK VENT FITTING
12	3	D4000-9	GROMMET
13	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
14	1	D4008-11	TANK HINGE HALF
15	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
16	1	D4023-3	FUEL CAP
17	1	D4025-5	FUEL SENDER
18	3	D4057-1	RETAINING RING
19	1	D4062-041	TANK SUPPORT ASSEMBLY
20	4	D4124-1	TAB
21	1	D4125-1	FWD SEDIMENT BOWL
22	1	D4125-3	AFT SEDIMENT BOWL
23	1	D4404-3	CUSHION, SIDE
24	4	D4404-5	CUSHION, FWD
25	1	D4462-1	BAFFLE
26	1	D4462-3	BAFFLE
27	1	D4463-041	TOP TANK ASSEMBLY
28	1	D4463-3	TANK AFT END
29	1	D4463-5	TANK UPPER CUT OUT
30	1	D4463-7	TANK FORWARD END
31	1	D4463-9	TANK BACK
32	1	D4463-11	TANK FRONT
33	1	D4463-13	TANK BOTTOM
34	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
35	1	D4577-1	REAR ACCESS PANEL
36	1	D4577-3	MIDDLE ACCESS PANEL
37	24	AN3-4A	BOLT
38	5	AN3H5A	BOLT
39	4	MS21042L3	NUT
40	4	MS35207-266	SCREW
41	37	NAS1149D0363J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 84698 MLJ
12/05/22

RELEASED
2012-05-09
WMS

D	ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4.	DC	12.05.02
C	UPDATED -041 WITH RE-DESIGNED D4463-11/13 REV. C PARTS, ZN B6-2. UPDATED -041 WITH RE-DESIGNED D4577-041/1-3/5 PARTS, ZN C6-2.	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS, REMOVED D4463-13. ADDED D4577-041/1-1/5 ACCESS PANELS, ZN C6-2.	DC	11.12.14
A	NEW ISSUE. REF PAR11-117 & CAR 11-54.	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>JS</i>	D4464	SHEET 1 OF 5
APPROVED	<i>WMS</i>	TITLE	SCALE
DE APPR.	<i>WMS</i>	TANK ASSEMBLY	NTS
DATE	12.05.02	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

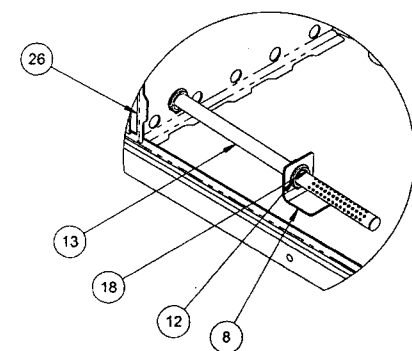
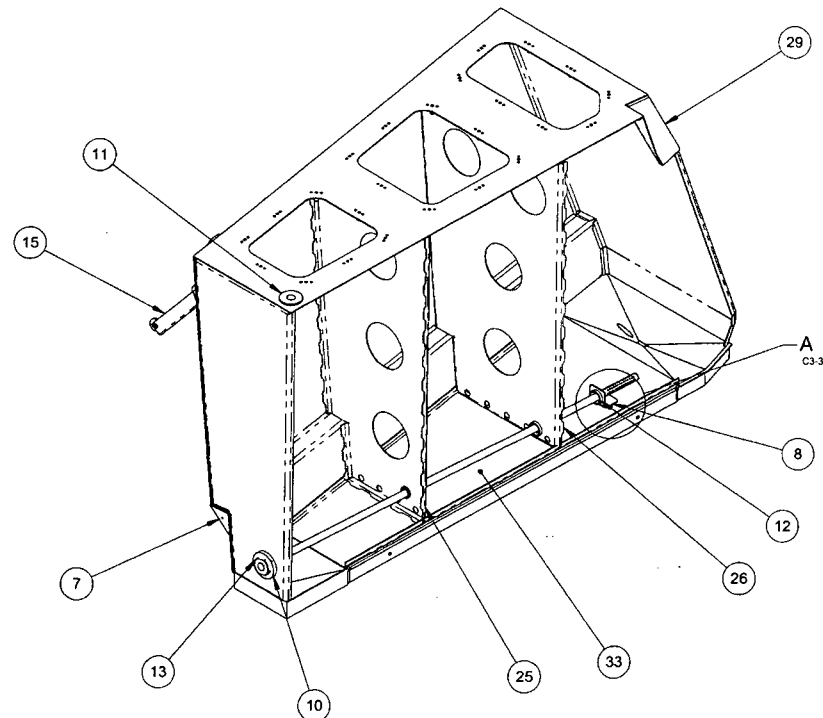
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

24698



DETAIL A
ROTATED FOR CLARITY
SCALE 2X
B6-3

D4464-041 FUEL TANK ASSEMBLY
D4463-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL

RELEASED
2012-05-09
WJ

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO. D4464	REV. D
MFG. APPR.	<i>JS</i>	SHEET 3 OF 5	
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	TANK ASSEMBLY	NTS
DATE	12.05.02	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

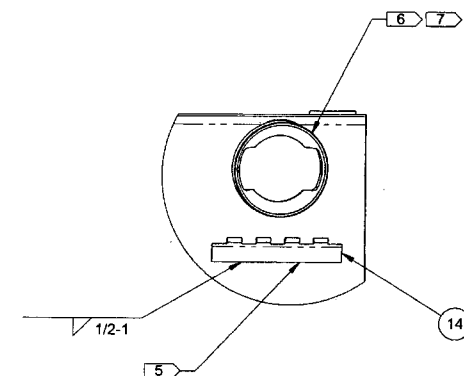
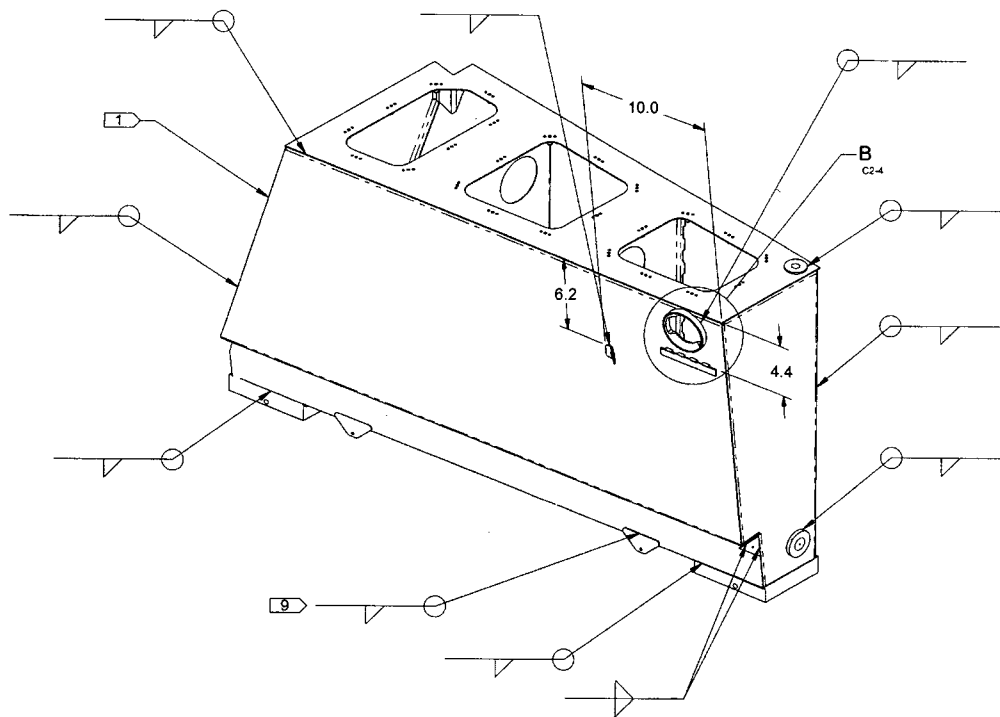
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

24698



**DETAIL B
ROTATED FOR CLARITY
SCALE 2X**
C2-4

**D4464-041 FUEL TANK ASSEMBLY
WELDING DETAIL**

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
- END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
- ALL SWARF REMOVED
- 3) ACCEPTABLE TO DRILL 6 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 4) ACCEPTABLE TO DRILL 7 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) CENTER HINGE BELOW FUEL CAP FLANGE
- 6) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 7) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 8) WELD PER DART QSI 004
- 9) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING;
D4124-1 TABS MAY BE HAND FORMED AS REQUIRED TO FIT D4062-041 ASSEMBLY BEFORE WELDING.



RELEASED
2012-05-09

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>JS</i>	D4464	SHEET 4 OF 5
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	TANK ASSEMBLY	NTS
DATE	12.05.02	COPYRIGHT © 2011 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

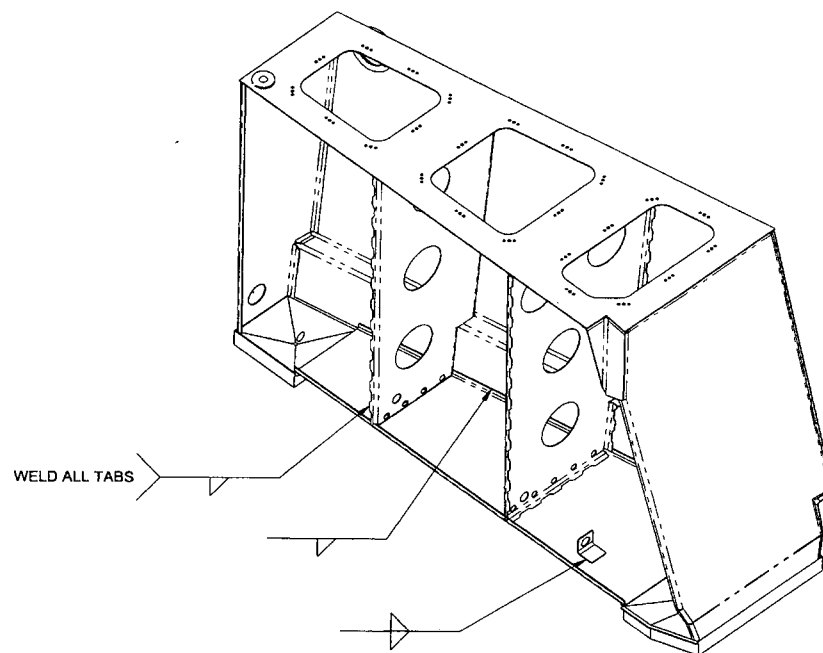
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84698



**D4464-041 FUEL TANK ASSEMBLY
WELDING DETAIL**

RELEASED
2012-05-09
MAR

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. D
MFG. APPR.	BC	D4464	SHEET 5 OF 5
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	TANK ASSEMBLY	NTS
DATE	12.05.02	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries